

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003881**Date Inspected:** 25-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih Chien, Wu Zhi Feng			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** bottom plates, edge plates, side panels**Summary of Items Observed:****Sub-assembly - Bay 3**

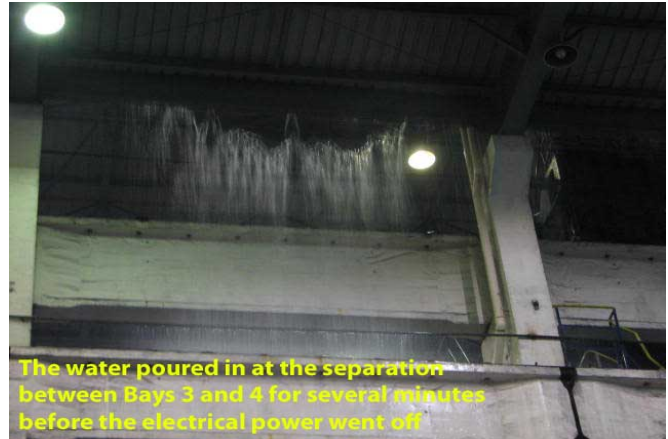
Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed approximately 55 ZPMC workers performing the following: layout and cleaning of plates where welding of ribs will be performed on BP062-001 and EP105A; fit-up and SMAW tacking of ribs to BP35; FCAW-G of W21 x 57 beam flange and web butt welds before beams are longitudinally cut into T-ribs; grinding edged of T-ribs before welding to EP98-001; approximate 24mm patterned holes being drilled in T-rib ends for BP116; oxy-fuel preheating and subsequent FCAW-G of ribs to SP400A; applying electric heating pads to BP178A. Also present in this bay were ZPMC CWI's Chen Chih Chien and Wu Zhi Feng as well as ABF QC's Li Jing Bo and Kevin Cheung. Although it was raining heavily outside, the rain did not appear to be affecting the welding inside this bay as late as 0915 hours. Items observed appeared to comply with project specifications.

Sub-assembly - Bay 4

At 0915 hours, QA Inspector entered this bay and observed rain water pouring in from the roof in solid sheets at the separation between Bays 4 and 5. All work appeared to be stopped, at least temporarily. Then at 0925 QA Inspector observed rain water pouring in from the roof in solid sheets at the separation between Bays 3 and 4. At 0936 hours the electrical power in the entire Bays 3, 4, and 5 failed. All lighting was out and no welding or other work was being performed. The power remained off during the entire day shift. Present in this bay were ZPMC CWI's Shazhi and Yu Dong Ping as well as ABF QC Larry Luo, although no welding work was observed by QA Inspector.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
